

Work Order ID 78139

78139

Page 1

December-29-11 10:34:52 AM

Item ID: D2661-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH Fwd Aft Out 206
 Start Date: 29/12/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								

100 0.00
100 HAAS CNC VERTICAL MACHINING #1
 HAAS I Memo 0.00 F.K 12/01/23 10 /
 HAAS CNC vertical machine #1 Program part number and batch number
 MACHINE AS PER DWG AND FOLIO FB071
 FOLIO REV: E
 DWG REV: E

110 0.00
110 CONVENTIONAL MILLING MACHINE
 Mill Conv Memo 0.00 F.K 12/01/23 10 /
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	F.K. 26	12/01/23		10	/		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	12-01-26					
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							10 BL 12-22

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

150

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

0.00

0.00

0.00

QC3- Inspect Part Finish

Memo

160

160

QC

Quality Control

170

170

Packaging

Packaging

Identify as per dwg & Stock Location

Memo

10X0 M-12/02/03

10 BX 12-23

644/7 (10)

M119480

7-20

32007

7-50

437

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

Handwritten: H.C.S. 12/02/06 [Signature]

Handwritten: 12/20/26 (10)

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Picklist Print

December-29-11 10:34:56 AM

Page 1

Work Order ID: 78139

78139

Parent Item: D2661-2

D2661-2

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 29/12/2011

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	92.0000	1	10			
D6101-003									**				
Saddle Billet, 7075													

Location	Loc Qty	Loc Code
MAT040	16	
73775	2	
73780	7	
MAT042	-7	
MAT044	83	
73769	1	
76837	82	
77562		

10 F.K 12/01/23.

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DART AEROSPACE LTD	Work Order: 78139
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.133	.133	.133	.133	129	
B	0.100	0.140		.120	.120	.120	.120	120	
C	1.125	1.145		1.1327	1.133	1.1333	1.1326	1.1324	
D	0.615	0.685		.680	.680	.680	.680	.680	
E	0.240	0.260		.253	.253	.253	.253	.253	
F	1.313	1.343		1.323	1.323	1.323	1.323	1.323	
G	0.210	0.230		.225	.225	.225	.225	.222	
H	0.100	0.180		.135	.135	.135	.135	.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.5729	1.5735	1.5736	1.5727	1.5724	
K	0.235	0.240		.236	.236	.236	.236	.236	
L	0.100	0.120		.111	.111	.111	.111	.111	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.2500	1.2500	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.314	.314	.314	.314	.314	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.797	.797	.797	.797	.796	
W	0.540	0.560		.548	.548	.549	.549	.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.260	.260	.260	.260	.257	
Z	0.912	0.932		.922	.921	.922	.920	.923	
AA	0.490	0.510		.500	.500	.499	.499	.497	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	FK
Date:	12/01/23 / 12-01-24

Audited by:	SK
Date:	12-01-26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	

Dart Aerospace Ltd

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Description: 206 Saddle, Outboard, Right side		Part Number: D2661-2
Inspection Dwg: D2661 Rev. D		Page 1 of 1

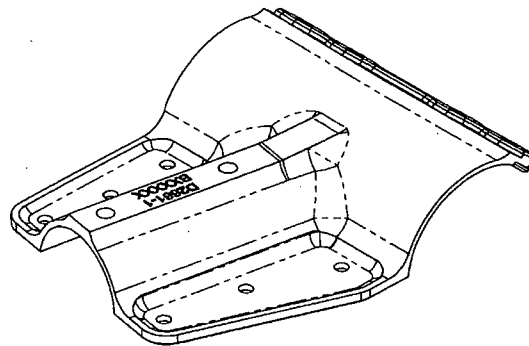
Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					10 By	Date
				6 X	7 X	8 X	9 X	10		
A	0.100	0.140		.130	.130	.130	.130	.130		
B	0.100	0.140		.120	.120	.120	.120	.120		
C	1.125	1.145		1.1323	1.132	1.132	1.132	1.132		
D	0.615	0.685		.680	.680	.680	.680	.680		
E	0.240	0.260		.253	.253	.253	.253	.253		
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G	0.210	0.230		.225	.225	.225	.225	.225		
H	0.100	0.180		.135	.135	.135	.135	.135		
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490		
J	1.565	1.585		1.5729	1.572	1.572	1.572	1.572		
K	0.235	0.240		.237	.237	.237	.237	.237		
L	0.100	0.120		.111	.111	.111	.111	.111		
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512	.512		
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314	.314		
S	0.315	0.322		.316	.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.797	.797	.797	.797		
W	0.540	0.560		.548	.548	.548	.548	.548		
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257	.257		
Z	0.912	0.932		.922	.922	.922	.922	.922		
AA	0.490	0.510		.500	.500	.500	.500	.500		
AB	0.178	0.198		.188	.188	.188	.188	.188		
AC										
AD										
AE										
AF										
Accept/Reject										

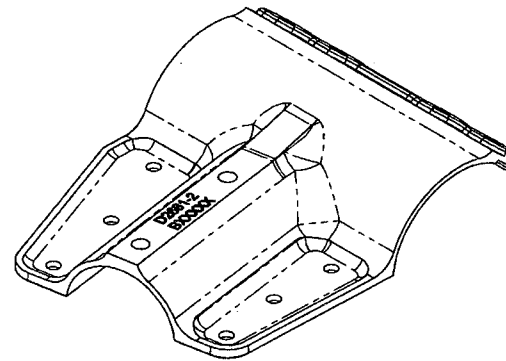
Measured by:	RF
Date:	12/01/24

Audited by:	K
Date:	12-01-26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

SHOWN
REF. TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78139-MCJ
11112129

RELEASED
2011-11-16

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG, 0.687 WAS 0.547 (B6-2,B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25

DESIGN	GP	DART AEROSPACE USA, INC.	
DRAWN	GP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	MA	D2661	SHEET 1 OF 5
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	SADDLE, OUTSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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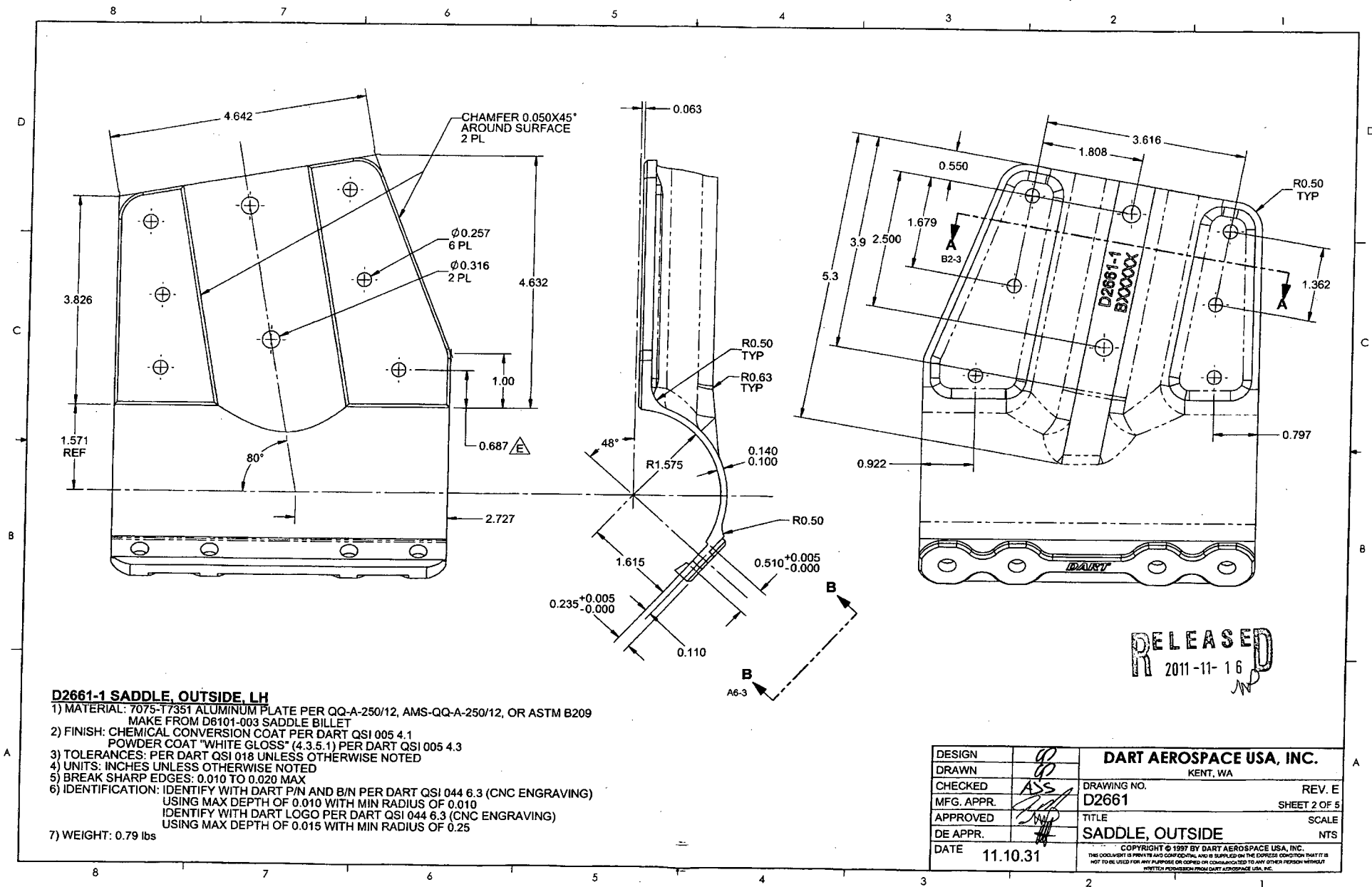
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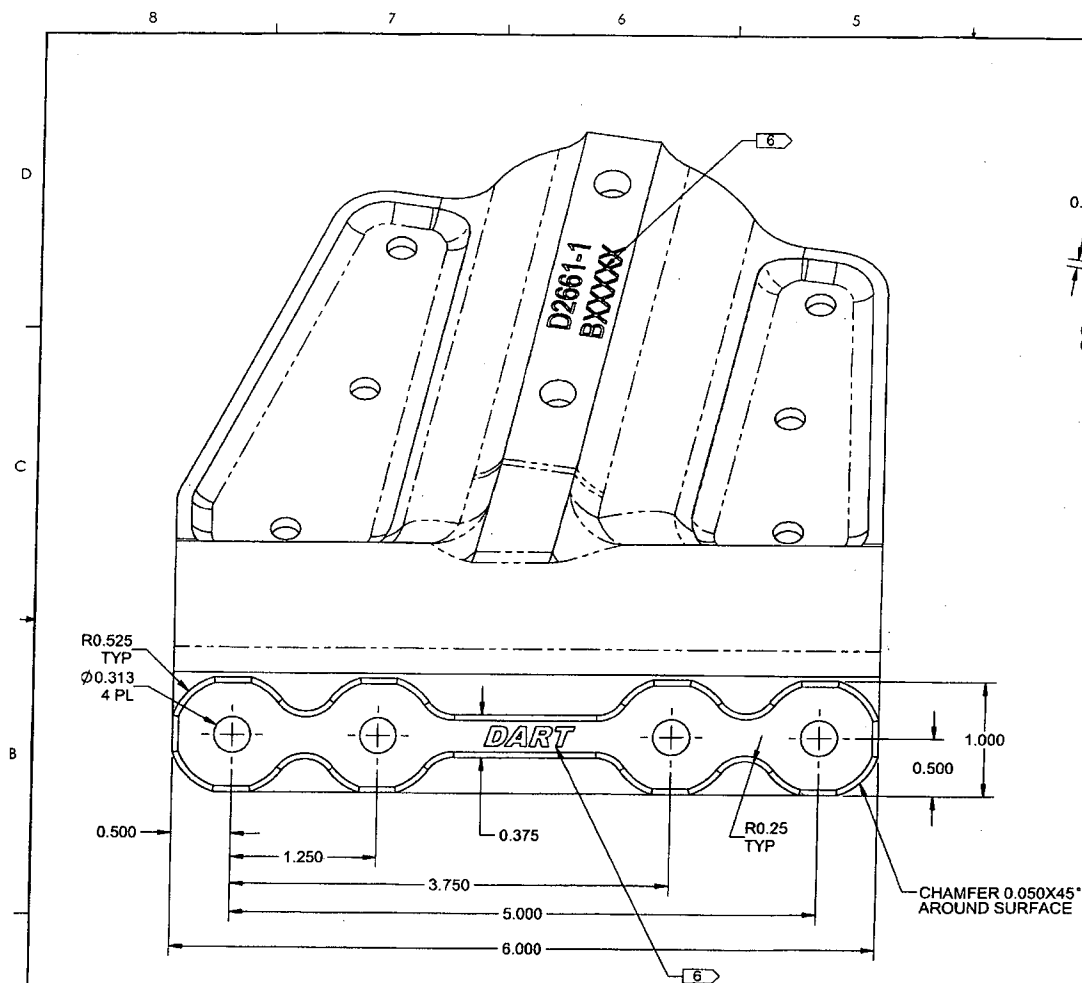
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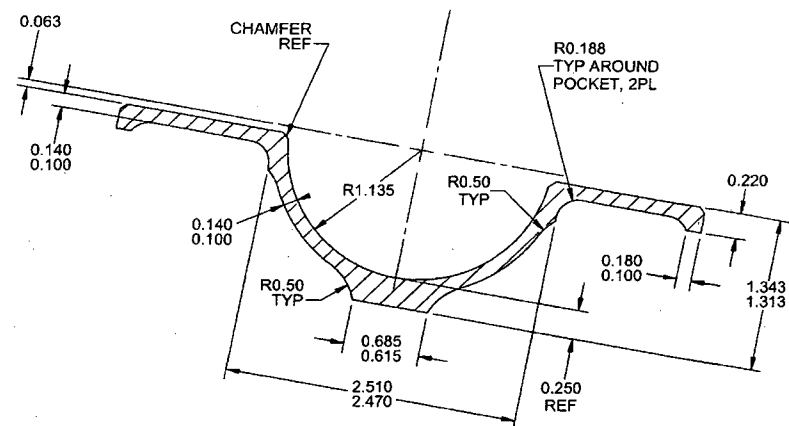
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NOTE: Date & initial all entries

78139



VIEW B-B
SCALE 1.5X
VIEW ROTATED



VIEW A-A
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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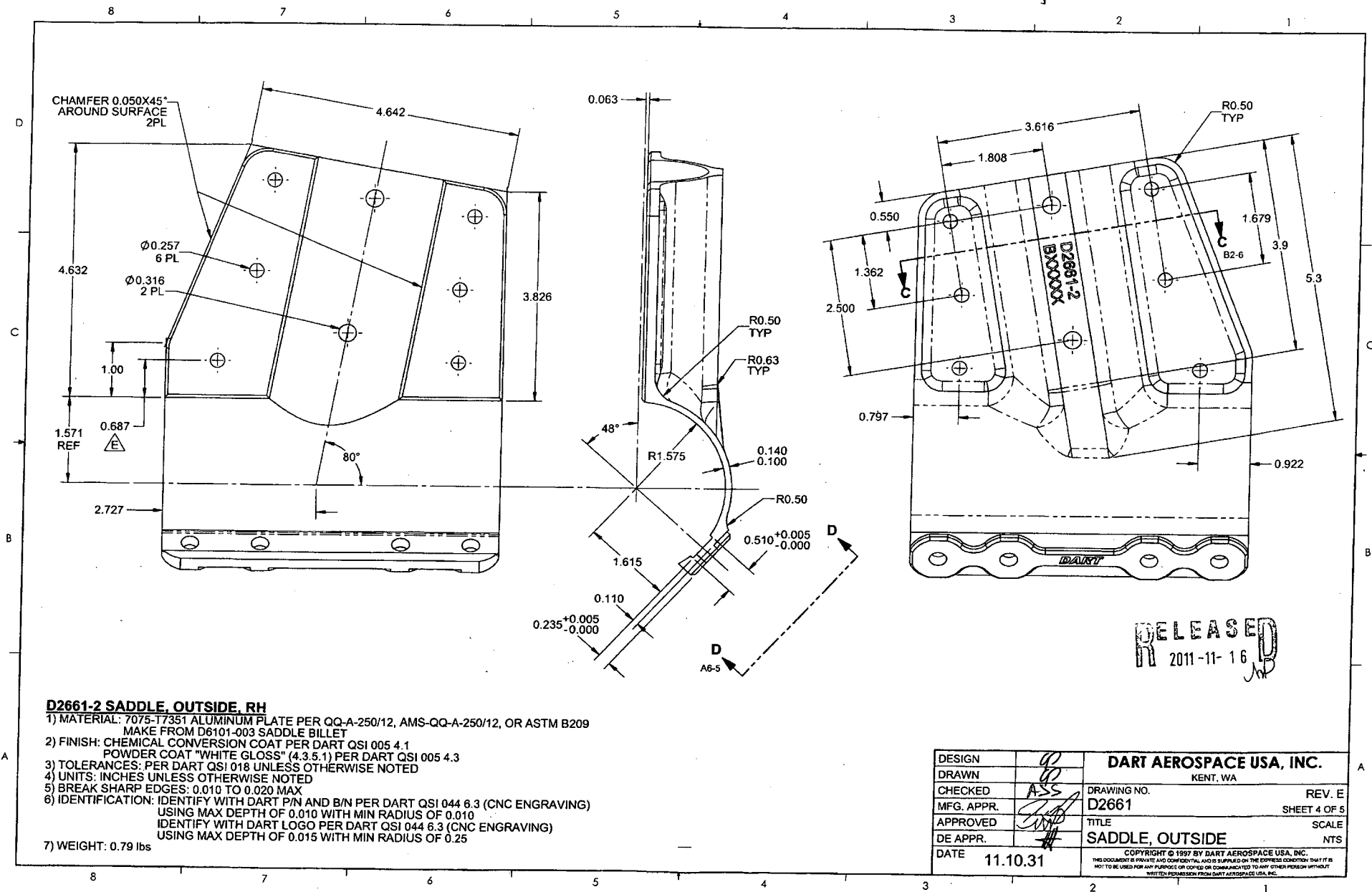
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RELEASED
2011-11-16

D2661-2 SADDLE, OUTSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 4 OF 5
APPROVED		TITLE	SCALE
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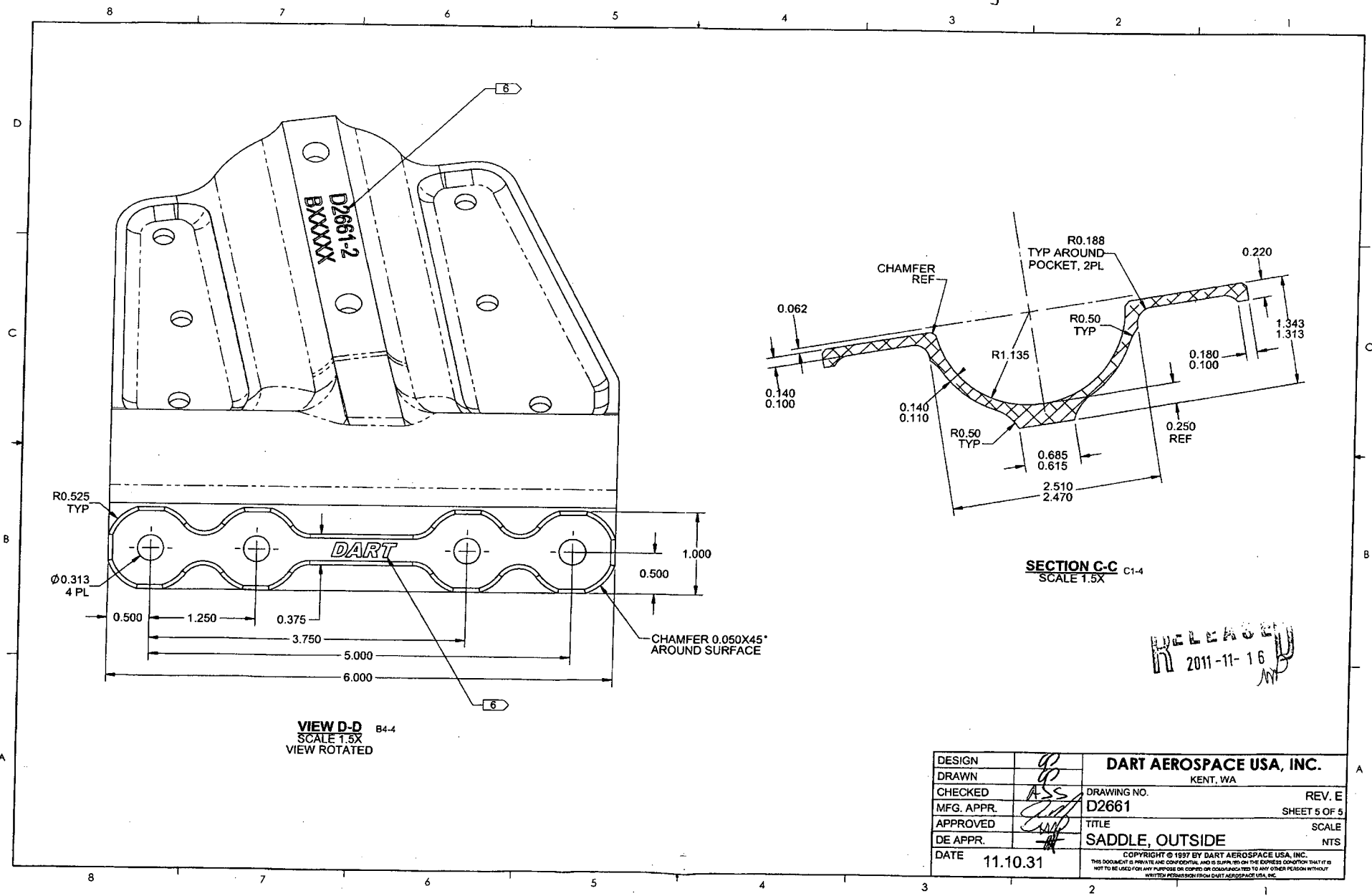
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries